



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

D5336-041
Job Sheet 180714



Part No: D5336-041

Job Qty: 1 ea

Part Name: Basket Lid Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/12/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B SHEETS 1,2,3,7 IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM IPP REV:B 17.03.27 AS PER REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/31/18	7/31/18	0.00	0.00	Start Up Large Fab-6		2018-08-27
100	Large Fab	1 pcs	7/31/18	7/31/18	0.00	8.02	Large Fab 1		
110	QC	1 pcs	7/31/18	7/31/18	0.00	0.00	QC9		18-08-30
120	QC	1 pcs	7/31/18	7/31/18	0.00	0.00	QC5		18-08-30
130	Powdercoat	1 pcs	7/31/18	7/31/18	0.00	0.11	Powdercoat4		18-09-05
140	HandFinish	1 pcs	7/31/18	7/31/18	0.00	0.75	HandFinish3		18-09-05
150	QC	1 pcs	7/31/18	7/31/18	0.00	0.00	QC3		18-09-05
160	Packaging	1 pcs	7/31/18	7/31/18	0.00	0.00	Packaging3-2		18-09-05
170	QC21-SA	1 Ea	7/31/18	7/31/18	0.00	0.00	QC21		18-09-05

Part Op 100 - 1- Assemble ribs , weld as per dwg D5336 using DT10196 2- Weld hinge (3) and Mounting brackets as per dwg Descriptions: D5336 ***inspect before welding mesh*** 3- Cut mesh as per dwg D5334-1 4- Tack weld mesh on basket as per dwg D5336 ***Make sure to place mesh correctly on lid, check with label plate before tacking mesh***

130 - *** Mask holes and sides of hinge prior to powdercoat*** Start Time: 2:35 Oven Temperature: 320°
Finish Time: 3:05

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5078989
D4016-3	Hinge Half, Lid	3 Ea (3 ea)	90-Start up Operation	5083907
D5332-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	5101587
D5332-1	Rib	2 Ea (2 ea)	90-Start up Operation	5090552
D5332-13	Rib	3 Ea (3 ea)	90-Start up Operation	5018480
D5332-15	Rib	2 Ea (2 ea)	90-Start up Operation	5090600
D5332-19	Rib	2 Ea (2 ea)	90-Start up Operation	5090517
D5335-1	Data Plate	1 Ea (1 ea)	90-Start up Operation	163096
M304EX0.75-16F	Expanded Metal Flat SS	8.1600 sf (8.16 ea)	90-Start up Operation	5070544

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	59	0
	D4016-3	3	37	0
	D5332-041	2	2	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

D5332-1	2	8	0
D5332-13	3	6	0
D5332-15	2	13	0
D5332-19	2	8	0
D5335-1	1	6	0
M304EX0.75-16F	8	837	0

Part Specifications

Specifications could not be found.

Plex 7/12/18 9:16 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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			QC / QA Coordinator Approval																		

Environment _____
Design _____
Doc/Data _____
Equip/Tooling _____
Handling/Pre _____
Material _____
Internal Transport _____
Tribal Knowledge _____
LOA _____
Substation _____
Past Expiry Date _____
Misidentified _____

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Date: 08/27/18

Various STC's

ORY

☐ Power Loss/Surge	☐ Positioned Wrong
☐ Folio/Program	☐ Outside Dimensions
☐ Grain	☐ Over/Under tolerance
☐ Weld	☐ Part Incorrect
☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Out of Sequence	☐ Part Moved
☐ Off-set	☐ Drawing
☐ Misabeled	☐ Finish
☐ Fit/Function	☐ Misread
☐ Misaligned/off center	☐ Turning Sequence

Container No: S105276

Part: D5336-041

Job No: 180714

Serial No/Batch: S105276

Revision: _____

Inspector: _____

Exp Date: _____

Instructions: _____